Work Orde		3151		*113	151*						Page 1
	D3535-35		A	Accept	*N900	0040	100)* s	etup Stai	^t *N	S1*
Revision ID: Item Name:	Stainless Steel	Weemlete Aft						_	Sto		
		•							•	, , ,	S2*
	2/10/14	Start Qty: 16.00	1 1 7		Cust Item	ID:					
Required Date: Reference:	2/10/14	Req'd Qty: 16.00	*16*		Customer	:					
	D Di		D-4-1/02-12	T. 1				R	tun Star	¹ *N!	D1*
Approvals:		n: <u>ML</u> 5				Date:			Sto)	
	QC:		Date:	SPC (Y/N):	I	Date:			•	*N	R2*
Sequence ID/ Work Center ID)	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revi	ision Nbr			-			<u> </u>			
D3535	Rev	В									
100				0.00							
100		FLOW WATER JET						16	_ 0_		Ьe
Waterjet		Memo		0.00							02-27-1
FLOW CNC Waterje	et	1-Cut as pe Deburr if no	er Dwg D3535 Dwg Rev: ecessary	Prog Rev: 2	>_ 2-						
110		QC2- Inspect parts off n	nachine FAI/FAIB	0.00							
110						, f			43		L o
QC		Memo		0.00				10			D2-27-
Quality Control					·						
120	9 % 30 3	QC8- Inspect parts - sec	cond check	0.00	>			./			
*12 0 *				· · · · · · · · · · · · · · · · · · ·	0			16_			
QC Ouality Control		Memo		16141 30.0	38	-					

Quality Control

DQA:			Date:											•	abla
						WORK ORDER NON	-CC	ONFO	RMANCE / L	JPDATE					AEROSPACE
QA Closed:			Date:								W	ork Order up	date only		
Work Orde	er:					DISPOSITION				AGAINST	DE	PARTMENT	/PROCESS		
Part N	•					Rework Scrap Use-as-is Suspected Unapproved			Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite		1	Water Jet d. Eng. Coor. re/Packaging Supplier		Engineering Quality Other
Root					Desci	ription of work order update	ı	Initial	A	ction		Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Des	cription		Date	Verification	1	QC Inspector
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved															
							FA	ULT CAT	regory						
Landi		Bending Centre No Cracks Crimp/Kir Cuffs Crushing Heat Trea Inspection Marks/Ch Turning S	nk/Ripple at n Strip in natter	/Wave		General Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes Finish		Grain Hardwa Inspecti Instruct Misalig Mislabe Misread Off-set	ion Incomplete/licions Incomplete gned/off center eled d	/Unclear		Outside Dim Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	tolerance ct ssing Vrong		Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled Other
		Wave/Tw	ist in Tub	e		Fit/Function		Out of	Sequence						

February-12-14 8:43:26 AM

Item ID: Revision ID: Item Name:	D3535-35 Stainless Stee	el Wearplate Aft		Accept	*N900	<u>040</u>	100)*	Setup	Start Stop	1 71	S1* S2*
Start Date: Required Date Reference:	2/10/14 : 2/10/14	Start Qty: 16.00 Req'd Qty: 16.00	*16* *16*		Cust Item l Customer:	D:					ı u.	
Approvals:		an:	Date:	Tooling: SPC (Y/N):		ate:			Run	Start Stop	~ <i>V</i>	R1* R2*
Sequence ID/ Work Center I 130 *120* Brake NC Brake NC	(D		necessary2-Form on Brake DT8326.3-Identify as D35	Set Up/ Run Hours 0.00 0.00 as per Dwg D3535 using Jig 35-35.	Tool ID	Tool # DAS 30 9-89	Plan Code	Accept Qty	t Rejo Qty		Reject Number	Insp. Stamp
140 *1 10* QC Quality Control		QC5- Inspect part comple	eteness to step on W/O	0.00 SKP 0.00 14/3/3	r			10				
150 *150*		Grey Sandtex(Ref:4.35)	(s) per QSI005 4.3	0.00				//-	0	K	4-3- ₁	1-/

Powdercoat

Powder Coating

Memo

DQA:			Date:											1	
						WORK ORDER NON	-CC	ONFO	RMANCE / I	UPDATE			_		AEROSPACE
QA Closed:			Date:			PR-		,			Wor	rk Order up	date only		
Work Orde	er:					DISPOSITION				AGAINST	DEP	ARTMENT	PROCESS		
Part i	•					Rework Scrap			Skid-tube Machining	Crosstube Small Fab			Water Jet d. Eng. Coor.] [Engineering Quality
NCR 1	No.					Use-as-is		Thern	noforming	Finishing Composite	$oldsymbol{oldsymbol{ iny}}$	Rec/Stor	e/Packaging Supplier		Other
Root					Desci	ription of work order update		nitial	A	ction		Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Des	cription		Date	Verification		QC Inspector
Design Doc/Data		•													
Equip/Tooling					8										
Handling/Pre							İ						,		
Material															
Operator															
Offset/Setup							İ							1	
Process															
Supplier									İ						
Training						-								1	
Transport															
Unapproved															
							FA	ULT CAT	TEGORY						
Landi	ng (Gear				General	_			ı				_	
		Bending				Bend	L	Folio/P	Program		Щ	Outside Dim	ensions	Pre	essure/Forced
		Centre No	ot Concer	ntric		BOM/Route		Grain			Щ°	Over/Under	tolerance	Se	t-up
		Cracks				Broken/Damage/Defect		Hardwa	ire			Part Incorred	ા _	Te	mperature/Cure
i		Crimp/Kir	nk/Ripple	/Wave		Burrs		Inspect	ion Incomplete/	Unqualified	Ш	Part Lost/Mi	ssing	_\w _'	eld
		Cuffs				Contamination		Instruct	tions Incomplete	e/Unclear		Part Moved	Ĺ	w	rong Stock Pulled
		Crushing				Countersink		Misalig	gned/off center	r		Positioned V	Vrong		
		Heat Trea	at			Cut Too Short		Mislabe	eled			Power Loss/	Surge	Ot	her
		Inspectio	n Strip in	Tube		Drawing		Misread	t		_	· · · · · · · · · · · · · · · · · · ·			
		Marks/Ch	natter			Drill Holes	<u></u>	Off-set			_				
		Turning S	equence			Finish		Out of 0	Calibration		_		,		****
		Wave/Tw	ist in Tub	oe .		Fit/Function		Out of 9	Sequence						

Work Orde	er ID	113151
February-12-14	8:43:26	AM

February-12-14				*11:3	151*							Page 3	,
Item ID: Revision ID: Item Name:	D3535-35 Stainless Stee	l Wearplate Aft		Accept	*N900	040	100) *	Setup	Start Stop	171.	S1* S2*	
Start Date: Required Date: Reference:	2/10/14 : 2/10/14	Start Qty: 16.00 Req'd Qty: 16.00	*16* *16*		Cust Item II Customer:	D:						.,	
Approvals:	Process Pla	an:	Date:	Tooling: SPC (Y/N):		ite:]	Run	Start Stop		₹1* ₹2*	
Sequence ID/ Work Center II 160 *160 *160 Comparison Comparis	D	Operation Description QC3- Inspect Part Finish Memo Identify as per dwg & Stoo	ck Location: FP-00	Set Up/ Run Hours 0.00 4 3 9 2 0.00 0.00	Tool ID	Tool #	Plan Code	Accept Qty K	Qty		Reject Number	Insp. Stamp	7 3
180 *1 A N* QC Quality Control		QC21- Final Inspection - Memo	Work Order Release	0.00				<u>M</u> [<u>_5</u>	17 MLJ	103-	04 13-01	

DQA:			Date:												
						WORK ORDER NON-	-CC	ONFO	RMANCE / U	PDATE					AEROSPACE
QA Closed:			Date:								Wo	ork Order up	date only		
Work Orde	er:					DISPOSITION				AGAINST	DE	PARTMENT	/PROCESS		
						Rework			Skid-tube	Crosstube			Water Jet	\neg	Engineering
Part N	lo.					Scrap			Machining	Small Fab		Pro	d. Eng. Coor.	ヿ	Quality
						Use-as-is		Thern	noforming	Finishing			e/Packaging	ヿ	Other
NCR N	lo				_	Suspected Unapproved			Large Fab	Composite			Supplier		
Root					Descr	ription of work order update		nitial	Act	tion		Sign &		\Box	
Cause		ate	Step	Qty		or non-conformance	Ch	ief Eng	Descr	ription		Date	Verification	۱	QC Inspector
Design															
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Material															
Operator															
Offset/Setup															
Process	_														
Supplier	_													İ	
Training	_													•	
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Unapproved															
							FAI	ULT CA	TEGORY						
Landii	ng Geal					General	_	1			_	1 .	. г	_	
		nding	_		—	Bend	<u> </u>	1	rogram			Outside Dim	F	-	Pressure/Forced
			t Concer	ntric	\vdash	BOM/Route		Grain				Over/Under	F		Set-up
	_	cks			<u> </u>	Broken/Damage/Defect	<u> </u>	Hardwa		_	<u> </u>	Part Incorred	F	—-	Temperature/Cure
	—;	-	k/Ripple	/Wave	<u> </u>	Burrs		1	ion Incomplete/Ur	•	_	Part Lost/Mi	ssing	\dashv	Weld
	Cuf				-	Contamination		4	ions Incomplete/l	Unclear	\vdash	Part Moved	L		Wrong Stock Pulled
9	_	shing			<u> </u>	Countersink	<u> </u>	1	ned/off center		\vdash	Positioned V	- r		
	—	at Trea		T b -	-	Cut Too Short	\vdash	Mislabe				Power Loss/	Surge [Other
	_		Strip in	rupe	\vdash	Drawing	\vdash	Misrea							
		rks/Ch				Drill Holes	<u></u>	Off-set							
		_	equence		<u> </u>	Finish	\vdash	4	Calibration						
	Wa	ive/Twi	ist in Tuk	oe		Fit/Function		Out of S	Sequence						

February-12-14 8:43:30 AM

Work Order ID: 113151

113151

Parent Item:

D3535-35

D3535-35

Parent Item Name: Stainless Steel Wearplate Aft

Start Date: 2/10/14

Required Date: 2/10/14

Start Qty: 16.00

Required Qty: 16.00

Comments:

IPP Rev:A New Issue 07-02-15 JLM

IPP Rev:B As per Rev B 07-08-31 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Primary Item Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA		Purchased	No		100	sf	134.1019	0.8022	13.51074	ļ		
M304S20 304/316 .040 Sheet	NGA							**		Ae	03	-27-14
			Location	o n	Loc	Otv	Loc Code					

Location MAT020 134.1018948 0.91 m126852 m127454 133.191895

128315 -- 13.52

DQA:			Date:												$^{\prime\prime}$ a a $^{\prime\prime}$
						WORK ORDER NON	-C(ONFO	RMANCE / U	PDATE					AEROSPACE
QA Closed:			Date:								Wo	ork Order up	date only		
Work Orde	r:		•••			DISPOSITION				AGAINST	DEF	PARTMENT	PROCESS		
	•					Rework			Skid-tube	Crosstube	\Box		Water Jet		Engineering
Part N	٥					Scrap		1	Machining	Small Fab		Pro	d. Eng. Coor.		Quality
						Use-as-is		Therr	noforming	Finishing		Rec/Stor	e/Packaging		Other
NCR N	ο					Suspected Unapproved			Large Fab	Composite			Supplier		
Root					Desc	ription of work order update		Initial	Act	ion		Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	nief Eng	Descr	ription		Date	Verification		QC Inspector
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Doc/Data	_			•								4			
Equip/Tooling	_										١				
Handling/Pre	_													İ	
Material	_								:					į	
Operator	_														
Offset/Setup	_														
Process	_						1				Ì				
Supplier	_													ı	
Training	_										ŀ			ŀ	•
Transport	\dashv					·									
Unapproved			<u> </u>	L	l			= 0.				·			,
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Landin						General]/r)	Г		0	Г	-	D
}	-	Bending	-+ Camaan	-+-:-	-	Bend BOM/Route	\vdash	Grain	Program	}		Outside Dim	F	-	Pressure/Forced
<u> </u>		Centre No Cracks	or Concer	ntric	<u> </u>	Broken/Damage/Defect	-	4			\vdash	Over/Under		_	Set-up
	-	Cracks Crimp/Kir	rk/Rinnla	/\A/ava		Burrs	\vdash	Hardwa	are ion Incomplete/Ur	agualified	\vdash	Part Incorred Part Lost/Mi		\neg	Temperature/Cure Weld
		Cuffs	ik) vihbie	y wave	-	Contamination	\vdash	1 .	tions incomplete/li	· · · · · · · · · · · · · · · · · · ·	-	Part Moved	-		
}	\rightarrow	Crushing			-	Countersink	\vdash	-	gned/off center	Jucieai	\vdash	Positioned V		ٔ لــــ	Wrong Stock Pulled
		Heat Trea	ıt			Cut Too Short		Mislabe	•	ŀ	-	Power Loss/		\neg	Other
		Inspection		Tube		Drawing	\vdash	Misrea		l	L	1 0 11 1033/	- L		<u> </u>
\ 		Marks/Ch				Drill Holes		Off-set			•				
 		Turning S				Finish		4	Calibration		•	·			
		Wave/Tw	•			Fit/Function		-1	Sequence		•				

DART AEROSPACE LTD	Work Order:	3151
Description: Wearshoe	Part Number:	D3535-35
Inspection Dwg: D3535 Rev: B	P:	age 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

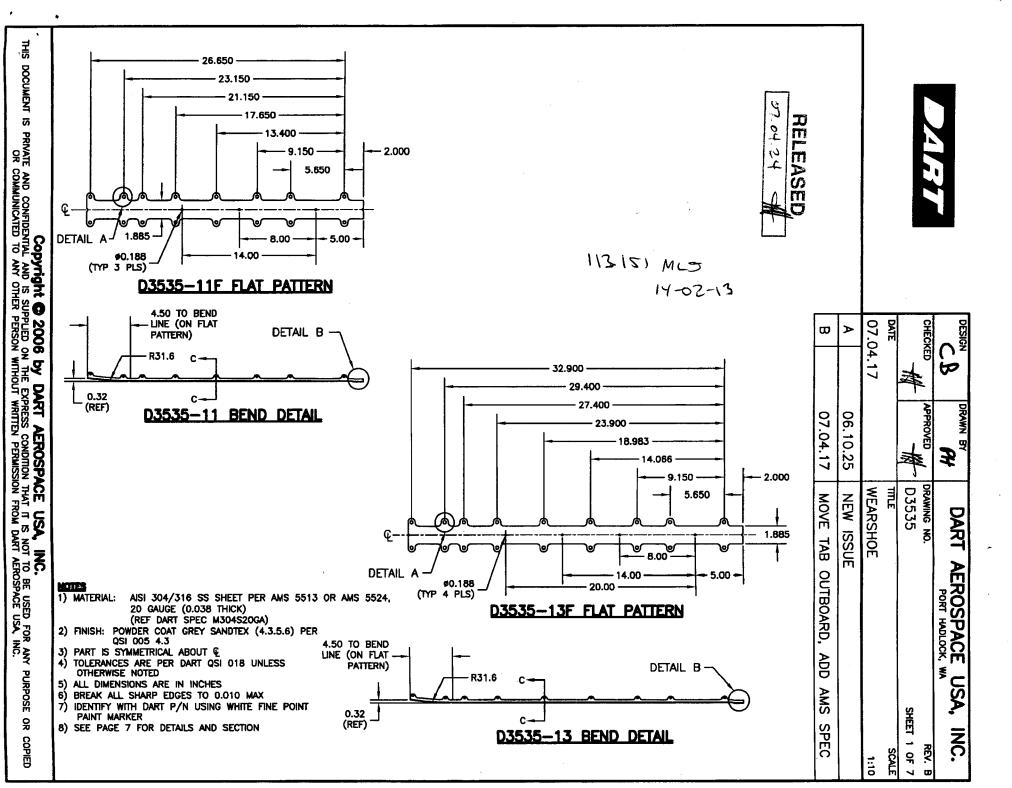
X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.000	+/-0.010	2.000	1		V	JKm-05
1.885	+/-0.010	1.886	-		~	
6.00	+/-0.030	6.00)		Т	JKm .06
6.75	+/-0.030	6.75	-		T	
Ø0.188	+0.005/-0.001	,191			V	
23.250	+/-0.010	23,250	-		7	
19.750	+/-0.010	19.750	1		7	
17.750	+/-0.010	17.750	•		τ	
14.250	+/-0.010	14. 250	1		7	
9.500	+/-0.010	9.500			7	
4.750	+/-0.010	4.750	_		Ť	
0.300	+/-0.010	.304	1		V	
0.300	+/-0.010	.304	1		V	
0.038	+/-0.010	,036	-		V	

Measured by:	De	Audited by:	Simp	Prototype Approval:	N/A
Date:	02-27-14	Date:	14/2/28	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	07.05.10	New Issue	KJ/JLM	E

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AEROSPACE PORT HADLOCK.

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SHEET

4 OF 7

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USA,

RC.

07.04.17

WEARSHOE



22.500 19.000 14.250 9.500 6.000 -2.000 1.885 DETAIL A **≠**0.188 (TYP 3 PLS) D3535-31F FLAT PATTERN



24.500
21.000
15.250
9.500 ———
2.000
1.885 DETAIL A
(TYP 3 PLS)
D3535-33F FLAT PATTERN

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D3535-	-33 RF	ND DET	TAII	

1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK)

(REF DART SPEC M304S20GA)
2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3

3) PART IS SYMMETRICAL ABOUT &

4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

5) ALL DIMENSIONS ARE IN INCHES

6) BREAK ALL SHARP EDGES TO 0.010 MAX

7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER

8) SEE PAGE 7 FOR DETAILS AND SECTION

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USA,

RC.

DATE

07.04.17

WEARSHOE



D3535-35F FLAT PATTERN

#0.188 (TYP 2 PLS)

DETAIL A

23.250 19.750

17.750

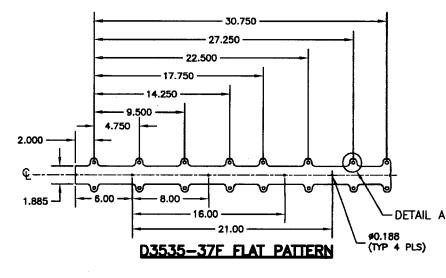
14.250 9.500

4.750

2.000

1.885





1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)

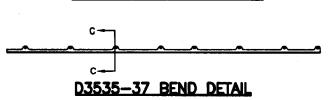
2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3

PART IS SYMMETRICAL ABOUT & TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

ALL DIMENSIONS ARE IN INCHES BREAK ALL SHARP EDGES TO 0.010 MAX

IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER

8) SEE PAGE 7 FOR DETAILS AND SECTION



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DOCUMENT

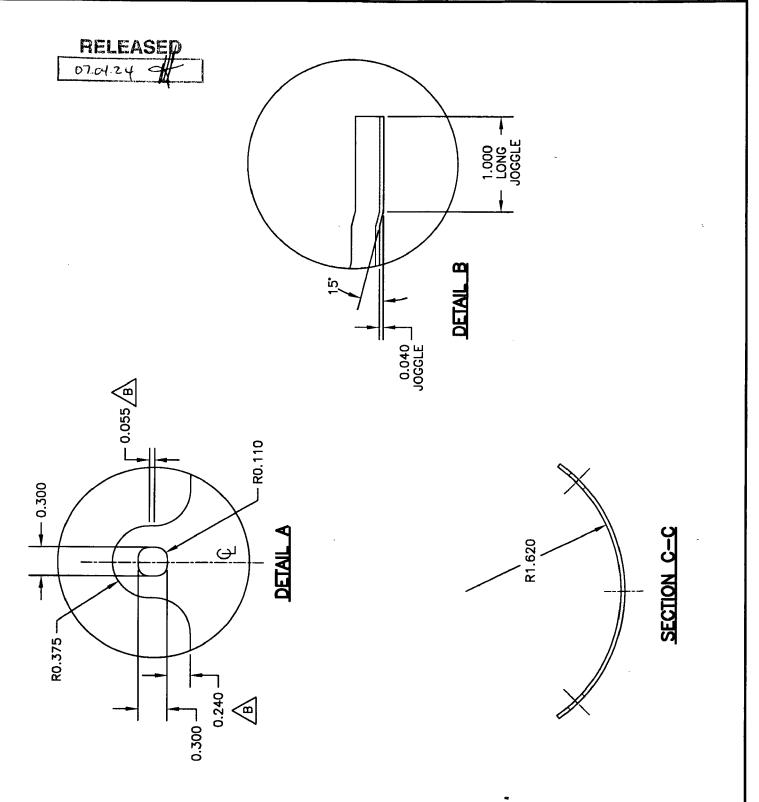
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CHECKED	APPROVED //	DRAWING NO.	REV. B
		D3535	SHEET 7 OF 7
DATE		TITLE	SCALE
07.04.17		WEARSHOE	1:1



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